Work Orde January-08-14 1		967		*110	96	7*			<b>L</b>	ر الاح			Page 1
Item ID: Revision ID:	D3575-5			Accept	*/	1900	040	100	)*	Setup		*N:	S1*
Item Name:	Cargo Floor Prot	ector									Stop	*N:	S2*
Start Date:	1/08/14	Start Qty: 1.00	*1*		(	Cust Item I	D:						
Required Date: 1	1/08/14	<b>Req'd Qty:</b> 1.00	*1*		(	Customer:							
Reference:		_	-										
Approvals:	Process Plan:	HB MLZ	Date: <u>\</u> \ <u>-\</u> O  - \\O	Tooling:		D:	ate:			Run	Start Stop	~1 <i>V</i> 1	R1*
	QC:		Date:	<b>SPC</b> (Y/N):		Da	ate:				ьюр	*N	R2*
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours		Tool ID	Tool #	Plan Code	Accept	t Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Revisi	on Nbr											
D3575	Rev A												
100				0.00									
*100*	I	FLOW WATER JET							i		٥		Jm14-02-
Waterjet	•	Memo		0.00							· · · · · · · · · · · · · · · · · · ·		
FLOW CNC Waterje	t	1-Cut as per Deburr if ned	Dwg D3575 Dwg Rev:_ cessary	A Prog Rev: A	2-								
110	(	QC2- Inspect parts off ma	achine FAI/FAIB	0.00									
*11 <b>0</b> *									1		Ó		Jn 14-02-
QC		Memo		0.00									
Quality Control					DAS 27								
120	(	QC8- Inspect parts - seco	ond check	0.00	9-89								
*120*				1,1	1/2				1				
QC		Memo		0.00	ノリ								

Quality Control

DQA:		<b></b>	Date:		_								`	
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE			_		AEROSPACE
QA Closed:			Date:							W	ork Order up	odate only		
Work Orde	or.					DISPOSITION			AGAIN	ST DE	PARTMENT,	/PROCESS		
Work Orac	٠٠٠.				<del></del>	Rework			Skid-tube Crosstul	<sub>se</sub> [	1	Water Jet		Engineering
Part f	No.					Scrap			Machining Small F		Pro	d. Eng. Coor.	┪	Quality
	•				_	Use-as-is			noforming Finishi	<u> </u>	4	re/Packaging	╗	Other
NCR I	۱o.					Suspected Unapproved			Large Fab Composi	te	]	Supplier		
Root					Desci	ription of work order update	ı	nitial	Action		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	۱	QC Inspector
Design														
Doc/Data											,			
Equip/Tooling														
Handling/Pre	Ш													
Material	Ш						Ì					1	İ	
Operator	Щ	-												
Offset/Setup	Ш													
Process														
Supplier		i												
Training	$\vdash$													
Transport	Н												-	
Unapproved			1	ŀ			FAI	III T CA	 TEGORY			]		
Landi						General	FA	ULT CA	IEGURT					
Lanui	_	Bending				Bend		leolio/i	Program	Г	Outside Dim	ensions [	$\neg$	Pressure/Forced
		Centre No	ot Concer	ntric	-	BOM/Route	-	Grain	Togram	$\vdash$	Over/Under	F	$\neg$	Set-up
	$\vdash$	Cracks	or concer	11110	$\vdash$	Broken/Damage/Defect	_	Hardwa	are	$\vdash$	Part Incorre	+	-	Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs	$\vdash$	-1	tion Incomplete/Unqualified	-	Part Lost/Mi	<b>}</b> -	$\neg$	Weld
		Cuffs	,	,		Contamination	<b>—</b>	1	tions Incomplete/Unclear		Part Moved			Wrong Stock Pulled
	-	Crushing			-	Countersink	$\vdash$	4	gned/off center		Positioned V	ـ Vrong		
	Г	Heat Trea				Cut Too Short	Г	Mislab	=		Power Loss/	· ·		Other
		Inspectio		Tube		Drawing		Misrea	d	_	·	٠ .		
	Г	Marks/Ct	-			Drill Holes	Г	Off-set						
		Turning S	equence			Finish		Out of	Calibration					
	Г	Wave/Tw	vist in Tuk	oe		Fit/Function		Out of	Sequence					

·												
Work Ord January-08-14				*110	967*							Page 2
Item ID: Revision ID: Item Name:	D3575-5 Cargo Floor I	Protector		Accept	*N900	<b>040</b>	100	)*	Setup	Start Stop	1 71	S1* S2*
Start Date: Required Date Reference:	1/08/14 : 1/08/14	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*	,	Cust Item l Customer:	D:	_			Storet		
Approvals:	Process Pl	an:	Date:	Tooling:	D	ate:			Run	Start	~1 <i>\</i> 1	R1*
••	QC:		Date:	SPC (Y/N):	D	ate:				Stop	*N	R2*
Sequence ID/ Work Center I 130 *120* Small Fab Small Fab	( <b>D</b>	Operation Description  Small Fab  Memo Deburr if N	ecessary.	Set Up/ Run Hours 0.00	1	Tool #	Plan Code	Accept Qty	Re Qt	ject y	Reject Number	Insp. Stamp
140 <b>*1 4 1 * * * * * * * * * *</b>		QC5- Inspect part comp  Memo	oleteness to step on W/O	0.00								

14/2/3 (1/2

Identify as per dwg & Stock Location:\_\_\_\_

PP1110978 0.00

150

\*150\* Packaging

Packaging

DQA:			Date:										TOACT
						<b>WORK ORDER NON</b>	-CC	ONFO	RMANCE / UPDATE				AEROSPACE
QA Closed:			Date:							W	ork Order up	date only	
Work Orde	ır.					DISPOSITION			AGAINST	DE	PARTMENT,	PROCESS	
Work Orac	•					Rework	1		Skid-tube Crosstube			Water Jet	Engineering
Part N	lo.					Scrap			Machining Small Fab		Pro	d. Eng. Coor.	Quality
	•					Use-as-is	1		noforming Finishing			e/Packaging	Other
NCR N	lo.					Suspected Unapproved	]		Large Fab Composite			Supplier	
Root	_				Desc	ription of work order update	Н	nitial	Action		Sign &		
Cause		Date	Step	Qty	Desci	or non-conformance	1	iief Eng			Date	Verification	QC Inspector
Design	$\dashv$	Dute	эсер	Qty		or non comormance	-	iici Liig	Description		Dute	vermeation	Qe mapeetor
Doc/Data							ļ						
Equip/Tooling							Ì						
Handling/Pre													
Material													
Operator													
Offset/Setup													,
Process							İ						
Supplier													
Training													
Transport													
Unapproved							1						
							FA	ULT CA	TEGORY				
Landi	ng (	Sear				General				_	<b>,</b>	_	
		Bending			L	Bend		Folio/F	Program	L	Outside Dim	ensions	Pressure/Forced
		Centre No	ot Concer	ntric	<u> </u>	BOM/Route		Grain		L	Over/Under	tolerance	Set-up
		Cracks			igspace	Broken/Damage/Defect	L	Hardwa		L	Part Incorre	<del> </del>	Temperature/Cure
		Crimp/Kin	k/Ripple	/Wave		Burrs	<u></u>	4 .	tion Incomplete/Unqualified	<u> </u>	Part Lost/Mi	ssing	Weld
		Cuffs				Contamination	_	4	tions Incomplete/Unclear	L	Part Moved	L	Wrong Stock Pulled
		Crushing				Countersink	<u>_</u>	1	gned/off center		Positioned V	_	<del>-</del> 7
	<u> </u>	Heat Trea			_	Cut Too Short	<u></u>	Mislabe			Power Loss/	Surge	Other
		Inspection	-	Tube	$\vdash$	Drawing		Misrea					
		Marks/Ch				Drill Holes	$\vdash$	Off-set					·
	<u> </u>	Turning S				Finish	$\vdash$	-{	Calibration				
		Wave/Tw	ist in Tub	oe -		Fit/Function		Out of	Sequence				

· · · · · · · · · · · · · · · · · · ·												
Work Ord January-08-14			,	*110	1967*						Page 3	3
Item ID:	D3575-5			Accept	*N900	040	100	)* s	etup Sta	rt *N	S1*	
Revision ID:		_						-	Sto			
Item Name:	Cargo Floor	Protector							510	<sup>ν</sup> ×//	S2*	
Start Date:	1/08/14	Start Qty: 1.00	*1*		Cust Item I	D:						
Required Date	: 1/08/14	<b>Req'd Qty:</b> 1.00	*1*		Customer:							
Reference:			•									
Approvals:	Process P	lan:	Date:	Tooling:	D:	ate:		R	kun Sta	~1 <i>/</i> 1	R1*	
	QC:		Date:	<b>SPC (Y/N):</b>	D:	ate:			Sto	, *V	R2*	
Sequence ID/ Work Center I	D	Operation Description	,	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
160		QC21- Final Inspection	- Work Order Release	0.00								
*160*								MIJ	- 14-	02-03	>	
QC		Memo		0.00				70100				

Memo

Quality Control

MLJ 14-02-03

DQA:			Date:											•	TRACT
						WORK ORDER NON-	-CC	ONFO	RMANCE / U				_		AEROSPACE
QA Closed:			Date:								Wo	ork Order up	date only	┙	·
Work Orde	er:					DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
	•				_	Rework	1		Skid-tube	Crosstube			Water Jet	$\neg$	Engineering
Part N	lo.					Scrap			Machining	Small Fab		Pro	d. Eng. Coor.	ᅦ	Quality
	•					Use-as-is			noforming	Finishing		ı	re/Packaging	╗	Other
NCR N	lo.					Suspected Unapproved			Large Fab	Composite			Supplier		
Root	Ī				Desci	ription of work order update		nitial	Act	tion		Sign &		$\neg$	
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription		Date	Verification	<u>.                                    </u>	QC Inspector
Design				·											
Doc/Data															
Equip/Tooling							1								
Handling/Pre									ļ						
Material															
Operator	_														
Offset/Setup															
Process												l l			
Supplier	_														
Training	_														
Transport															
Unapproved							<u> </u>								
							FAI	ULT CA	regory						
Landii	$\overline{}$	1			_	General		1		1		1	r		l .
		Bending			-	Bend	<u> </u>		Program			Outside Dim	<b>-</b>	-	Pressure/Forced
		Centre No	ot Concer	ntric	_	BOM/Route	<u> </u>	Grain				Over/Under	- t-		Set-up
	-	Cracks			<u> </u>	Broken/Damage/Defect	<u> </u>	Hardwa				Part Incorred	<b>-</b>		Temperature/Cure
	_	Crimp/Kir	ık/Ripple	/Wave	<u> </u>	Burrs	<u> </u>	1 `	ion Incomplete/U	•		Part Lost/Mi	ssing	-	Weld
	-	Cuffs				Contamination			tions Incomplete/			Part Moved	Ĺ		Wrong Stock Pulled
		Crushing			$\vdash$	Countersink	$\vdash$	1	gned/off center		_	Positioned V		—	l
,		Heat Trea			<u> </u>	Cut Too Short	<b></b>	Mislabe				Power Loss/	Surge [	_	Other
		Inspectio	-	Tube	$\vdash$	Drawing	$\vdash$	Misrea							
		Marks/Ch				Drill Holes	$\vdash$	Off-set							
		Turning S	•		<u> </u>	Finish	<u></u>	4	Calibration						
		Wave/Tw	ist in Tub	e		Fit/Function		Out of:	Sequence						

Page 1

Work Order ID:

110967

Parent Item:

D3575-5

**Parent Item Name:** 

Cargo Floor Protector

**Start Date:** 1/08/14

Required Date: 1/08/14

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev : A New Issue 07.07.23

EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04 GE PLASTICS LEXAN SI	НЕЕТ	Purchased	No			100	sf	1,461.9900	10.666	12		Jm	14-02-3

127934

127934.

DQA:			Date:										
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE				AEROSPACE
QA Closed:			Date:							W	ork Order up	date only	
						DISPOSITION			AGAINST	DE	PARTMENT	/PROCESS	
Work Orde	r: -						,			_	1	\ <b>A</b> /-41-4	,
						Rework			Skid-tube Crosstube		0	Water Jet	Engineering
Part N	0.	· · · · · ·			_	Scrap			Machining Small Fab noforming Finishing		1	d. Eng. Coor. re/Packaging	Quality Other
NCR N	io					Use-as-is Suspected Unapproved	1	men	Large Fab Composite	_	Rec/3to	Supplier	
NCK N	٠					Suspected Onapproved	]		Large Fab Composite		j	Jupplier	ا لـا
Root	П				Desci	ription of work order update		nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design													
Doc/Data													
Equip/Tooling													
Handling/Pre													
Material													
Operator							1						
Offset/Setup							1						
Process													
Supplier							1						
Training	_								ļ				
Transport				,								ł	
Unapproved					<u> </u>								
							FA	ULT CA	TEGORY				
Landir					_	General	_	1	_	_	1		7
		Bending				Bend	$\vdash$	-1	Program	$\vdash$	Outside Dim	<del> </del>	Pressure/Forced
		Centre No	ot Concer	ntric	$\vdash$	BOM/Route	$\vdash$	Grain		$\vdash$	Over/Under		Set-up
	_	Cracks		•	<u> </u>	Broken/Damage/Defect	<u>_</u>	Hardwa		$\vdash$	Part Incorre	<u> </u>	Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave	<u> </u>	Burrs	$\vdash$	- '	tion Incomplete/Unqualified	-	Part Lost/M	issing	Weld
		Cuffs			-	Contamination	$\vdash$	-1	tions Incomplete/Unclear	$\vdash$	Part Moved	L	Wrong Stock Pulled
		Crushing			<u> </u>	Countersink	$\vdash$	-3	gned/off center		Positioned V		٦٠٠٠
		Heat Trea			<u> </u>	Cut Too Short	$\vdash$	Mislab		L	Power Loss/	Surge	Other
		Inspection		Tube	<u> </u>	Drawing	<u> </u>	Misrea					
		Marks/Ch			<u> </u>	Drill Holes		Off-set					
		Turning S			<u> </u>	Finish	_	-1	Calibration				
Į.		Wave/Tw	ist in Tub	oe -		Fit/Function		Out of	Sequence				

DART AEROSPACE LTD	Work Order:	110967
Description: Cabin Floor Protector	Part Number:	D3575-5
Inspection Dwg: D3575 Rev: A		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3005"	_		V	Jknoi
3.38	+/-0.030	3.38~	_		V	
6.50	+/-0.030	(b 50°	-		V	
26.13	+/-0.030	26.13"	-		۲	Jamou
30.13	+/-0.030	30.13'	-			
2.00	+/-0.030	200"	_		ν	
3.50	+/-0.030	3.60	_		ν	
14.25	+/-0.030	14.15	-	-	+	
25.13	+/-0.030	25.13	_		Τ	
29.38	+/-0.030	29.38	-		T	
30.38	+/-0.030	30.38	-		T	
31.50	+/-0.030	31.504	_		1	
1.00	+/-0.030	1.00"	_		v	
4.38	+/-0.030	4.38	,		ν	
14.50	+/-0.030	14.504	_		T	
16.00	+/-0.030	16.00			۲	
23.13	+/-0.030	73.13"	-		T	
26.88	+/-0.030	26.88	-			
27.69	+/-0.030	27.69"			T	
1.00	+/-0.030	1.00"	-		V	
3.75	+/-0.030	3.75"			V	
9.63	+/-0.030	9.63"	_		£	
16.13	+/-0.030	16.13			T	
28.06	+/-0.030	28.86"	_		7	
32.15	+/-0.030	32.15	DAS		T	

Measured by: Jm Audited by: 9-89 Prototype Approval: N/A

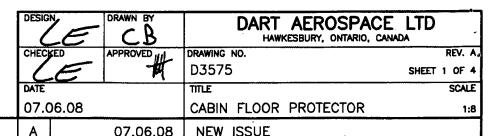
Date: 14-02-3

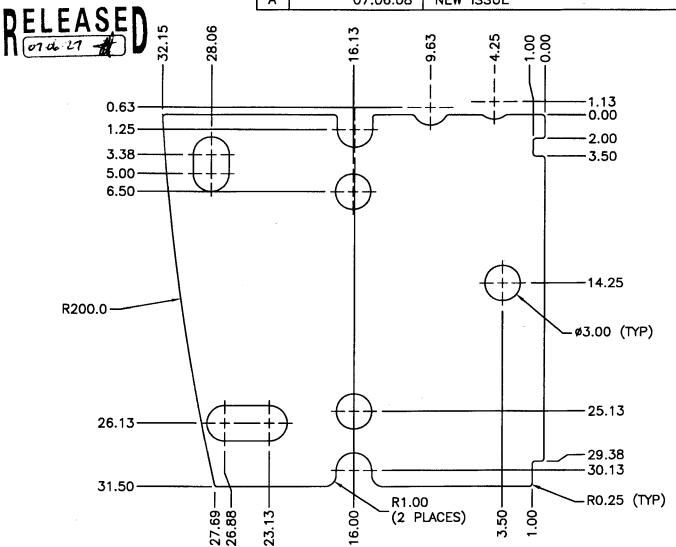
Date: 14-2-3

Date: N/A

Rev	Date	Change	Revised by,	Approved
Α	08.01.16	New Issue	KJ//DD	







110967 M 14-01+10

D3575-1 CABIN FLOOR PROTECTOR (SHOWN) D3575-2 CABIN FLOOR PROTECTOR (OPPOSITE)

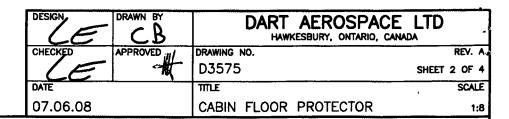
#### NOTES:

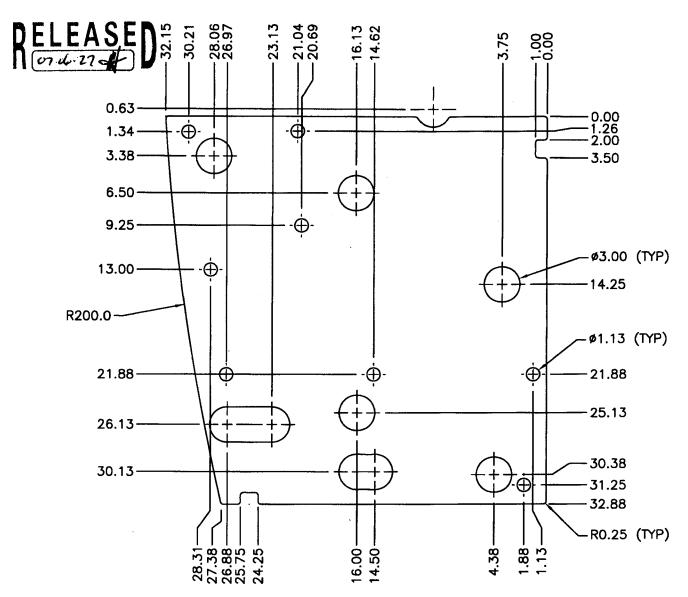
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-1/-2" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- CHECK PER TEMPLATE DT8966

Copyright © 2007 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.







#### D3575-3 CABIN FLOOR PROTECTOR

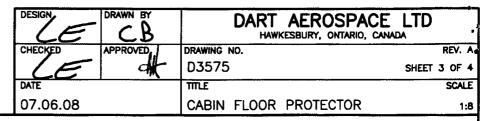
### NOTES:

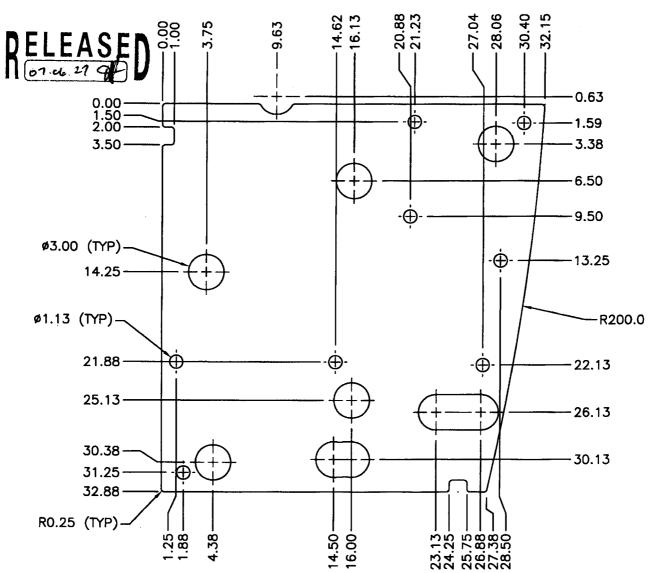
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-3" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8967

Copyright © 2007 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.







#### D3575-4 CABIN FLOOR PROTECTOR

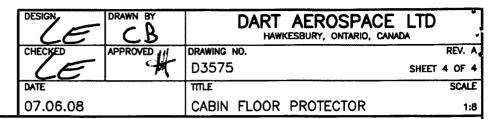
### NOTES:

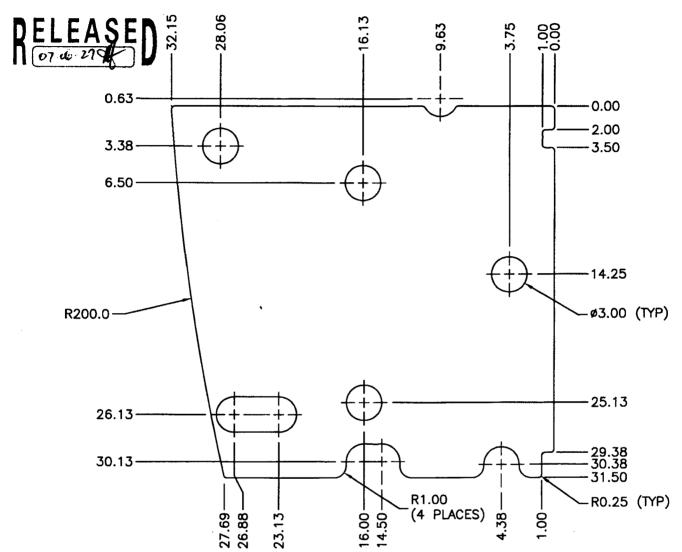
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-4" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8968

Copyright © 2007 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.







## D3575-5 CABIN FLOOR PROTECTOR (SHOWN) D3575-6 CABIN FLOOR PROTECTOR (OPPOSITE)

#### NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-5/-6" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8969

Copyright © 2007 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.